

Work Order ID 50472

July 10, 2009 2:23:19 PM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support

Start Date: 1/25/10

Start Qty: 40.00



Cust Item ID:

Required Date: 1/25/10

Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank: 2.00" x 1.00" x 2.550" long

0.00

0.00

mk 09/07/18

40

0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Machine as per Folio FA405 and Dwg D3278-1
2- Deburr and Tumble Identify as D3278-1

0.00

0.00

mk/mm 09/07/19

40

0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

mk/mm 09/07/19

40

0

W/O:		WORK ORDER CHANGES					
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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SA 09/04/20

40

Ø



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

UMD 09/07/20

40



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:00

OVEN TEMPERATURE:

320° FINISH TIME:

8:30

BL 09-07-23 (40)

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Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 39

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

27 S 09/07/23

route
(+40)

φ

P 9/17/24 (40)

09/07/24

W 09.07.24

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

July 10, 2009 2:23:19 PM

Work Order ID: 50472



Parent Item: D3278-1RevC



Parent Item Name: Support

Start Date: 1/25/10

Required Date: 1/25/10

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	63.0800	9.8400			



6061-T6 Bar 1.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

63.08

107129

7.03

110829

23.05

111571

33

9.840

JL 09/07/17

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	50972
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	✓			
0.359	+/-0.005	.359	✓			
0.609	+/-0.010	.612	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.481	✓			
R0.125	+/-0.010	R.125	✓			
0.119	+0.005/-0.004	.121	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.981	✓			
R0.13	+/-0.030	R.130	✓			
Ø0.257	+0.005/-0.000	Ø.258	✓			
R0.375	+/-0.010	R.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.503	✓			
R0.400	+/-0.010	R.400	✓			
R1.00	+/-0.030	R1.00	✓			
1.720	+/-0.010	1.723	✓			
R0.125	+/-0.010	R.125	✓			
0.125	+/-0.010	.129	✓			

Measured by:	gml	Audited by:	SA	Prototype Approval:	N/A
Date:	09/07/18	Date:	09/07/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	AF BE

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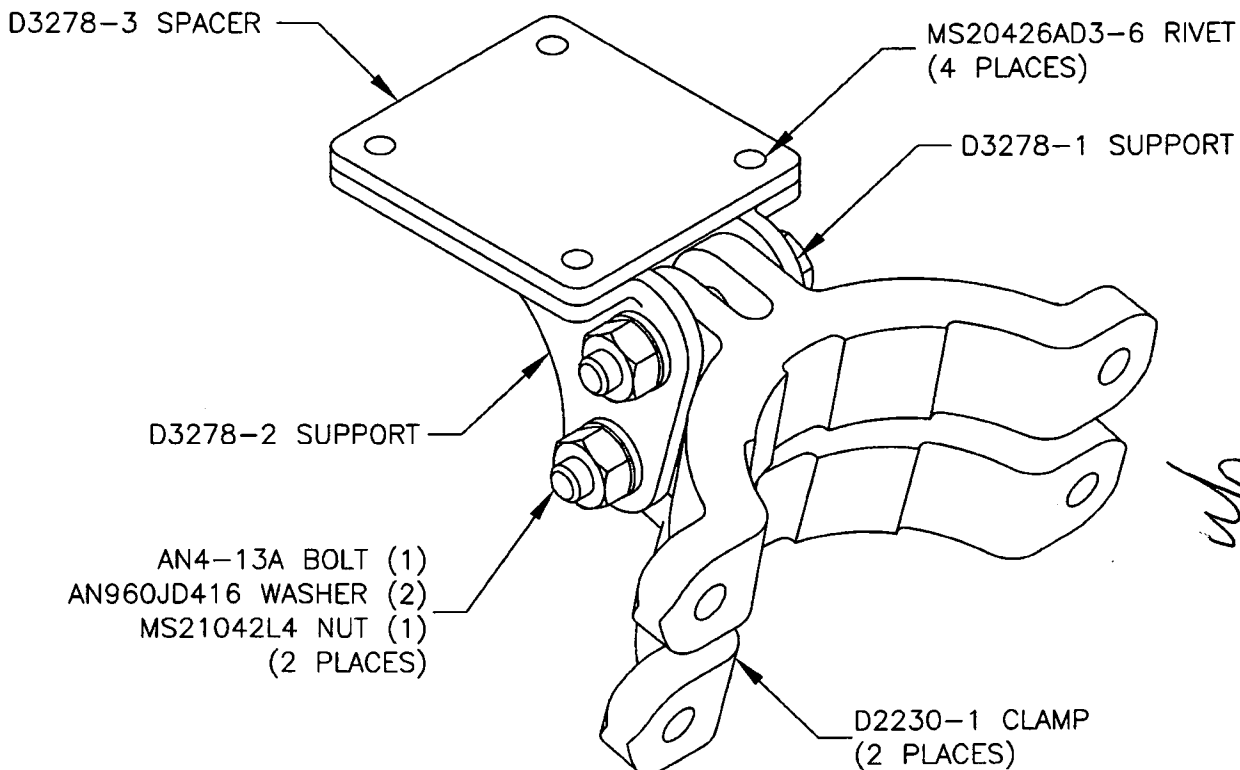
NOTE: Date & initial all entries

DART

DESIGN 99/	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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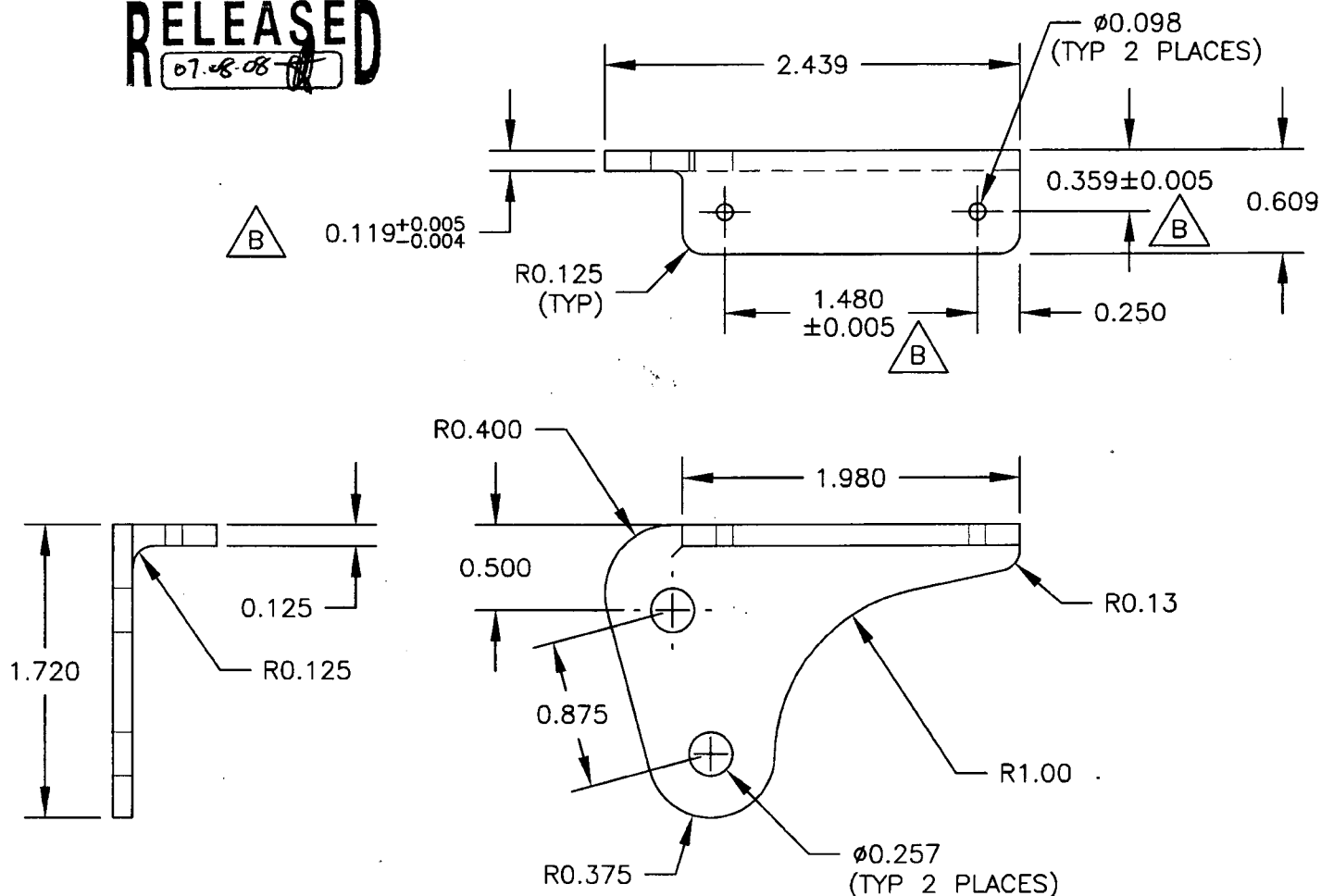
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DART

DESIGN <i>qp</i>	DRAWN BY <i>bc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>js</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRF"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO -0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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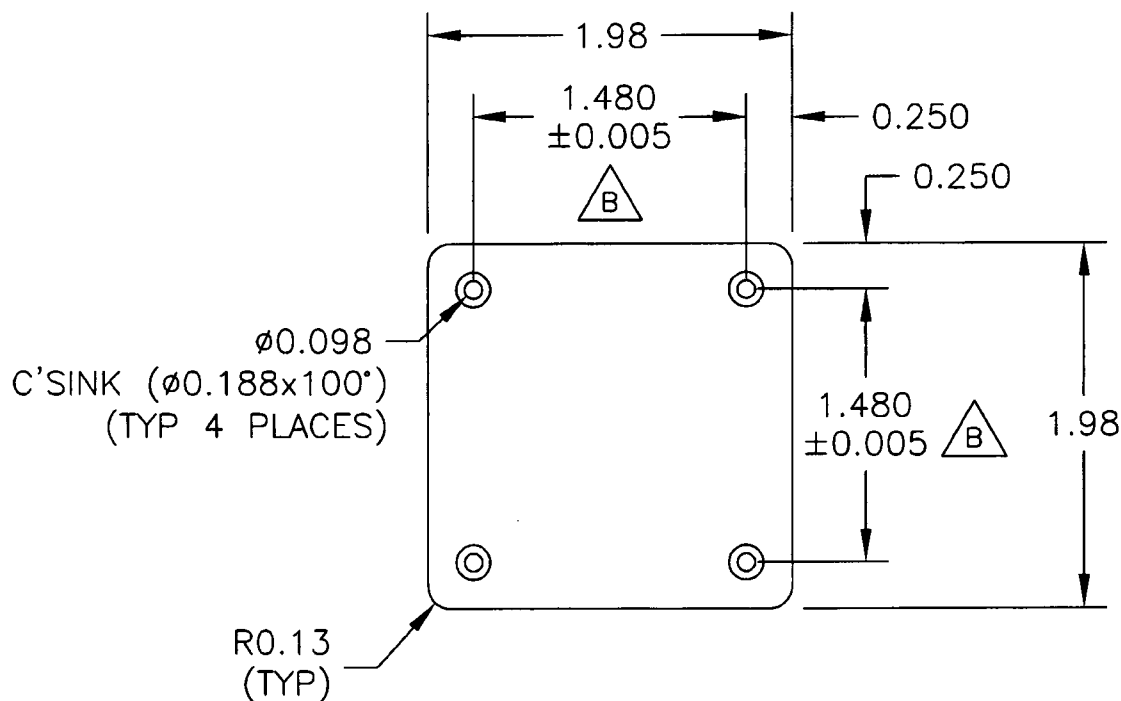
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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